

on the bosses, it was necessary to adopt some sort of floating construction such as that shown in the illustration. A number of jigs of this kind are in use in a large automobile factory and their action is very satisfactory. In the instance shown the work is located on a stud *J* from the previously reamed hole in the hub. It should also be noted that both hubs and bosses have been faced to size previous to the drilling operation.

A

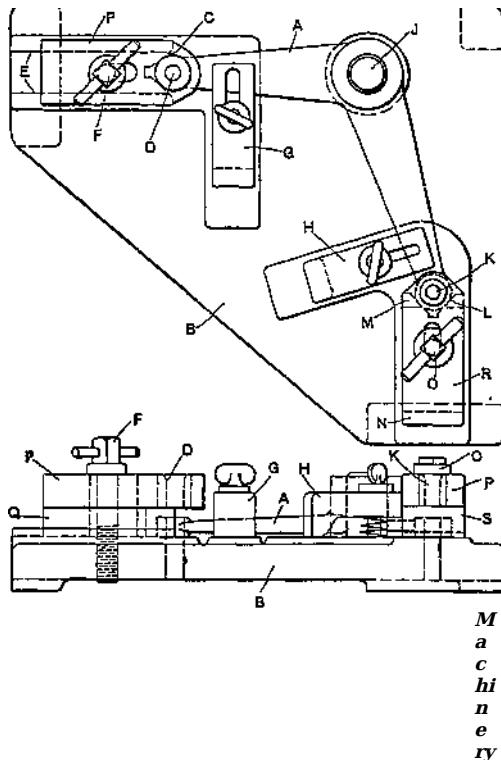


Fig. 3. Drill Jig with Floating
Bushings and Locating Vees

sliding V-block *Q* is carefully fitted to the slot *E* in the body of the jig, and on it is mounted the bushing plate *P* in which the bushing *D* is carried. After the piece has been placed in position the sliding block is pushed forward by the operator until the vee *C* comes up against the boss on the casting and locates it. The thumb-screw *F* locks the

block firmly in position, and the sliding clamp *G* holds the work. Another block *S* is also cut out in the form of a vee at L, but is not
17J